

Work Order ID 158269

Thursday, March 16, 2017 11:21:38 AM

158269

Page 1

Item ID: **D3825-041** Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly (Basket End)
Start Date: 3/29/2017 Start Qty: 8.00 ***g*** Cust Item ID:
Required Date: 4/3/2017 Req'd Qty: 8.00 ***g*** Customer:
Reference: SCHEDULED/C
Approvals: Process Plan:  Date: **MAR 16 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3825	C

100

0.00

1000

Large Fab

Large Fab

4.48

Large Fab

Memo**1- cut D3825-1 rib as per dwg D3825**

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-3 spacer bushing and bushing as per dwg D3825

A/R S.S. Rod Batch: **136695**

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

8 **Cy** **17-04-12**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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N900040100

Setup Start *NS1*

Stop *NS2*

g

Cust Item ID:

Start Date: 3/29/2017 **Start Qty:** 8.00

g

Customer:

Required Date: 4/3/2017 **Req'd Qty:** 8.00

Reference: SCHEDULED/C

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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130 QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

0.00

QC

Quality Control

Memo

⑧ 17.04.12

DAS
9
9-89

140	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

0.00

140

0.16

QC

Quality Control

Memo

(8) 17.04-12

DAS
9
9-89

150 Identify as per dwg & Stock Location: W4004 0.00

0.00

150

0.08

Packaging

Packaging

Memo

LOCATION WA004

8 5 17.04.12

DQA: _____ Date: _____



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160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.80							
Quality Control									

17/4/13

DAS
21
9-89

APR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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OTHER :																					

Picklist Print

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Page 1

Work Order ID: 158269

158269

Parent Item: D3825-041

D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 3/29/2017

Required Date: 4/3/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC IPP REV:B
12.07.24 AS PER REV.B DD VERF:EC IPP REV:C 12.08.08
AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3

Manufactured

No

100

Each

55.0000

1

8

D2327-3

Spacer Bushing

**

CS 17/03/31

Location

Loc Qty

Loc Code

WA004

55

148585

5

154190

50

CS ⑧

D3759-1

Manufactured

No

100

Each

205.0000

1

8

D3759-1

Bushing

**

Location

Loc Qty

Loc Code

WA004

205

145615

33

149531

28

150800

2

154959

60

157144

82

CS ⑧ CS

D4021-9

Manufactured

No

100

Each

192.0000

4

32

D4021-9

Bushing

**

Location

Loc Qty

Loc Code

WA004

192

145800

2

155371

190

CS ⑧

DQA: _____ Date: _____



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Work Order ID: 158269

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Parent Item: D3825-041

D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 3/29/2017

Required Date: 4/3/2017

Start Qty: 8.00

Required Qty: 8.00

M304TS0.750W.065

Purchased

No

100

f

1,042.804

2.125

17.89474

✓ *M304TS0 750W 065*

304 SQ Tube .75x.75x.065W

**

B137065

→ 24 CS 17-04-12

Location

Loc Qty

Loc Code

WA004

1042.804944

m133412

2.264944

m136378

93.54

m136907

147

m137065

800

CS (18)

DQA: _____ Date: _____



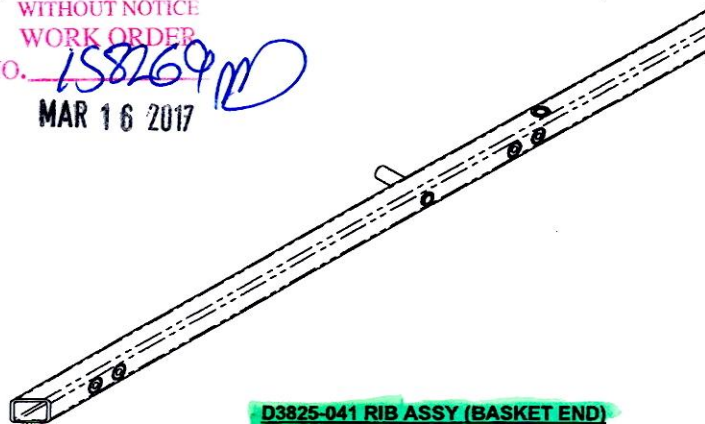
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QA Closed: _____ Date: _____

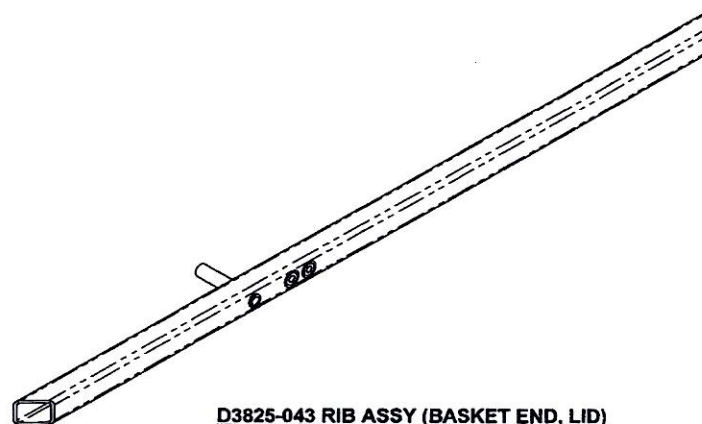
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *158269 MD*
MAR 16 2017



D3825-041 RIB ASSY (BASKET END)



D3825-043 RIB ASSY (BASKET END, LID)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3825-041	RIB ASSEMBLY (BASKET END)
		X	D3825-043	RIB ASSEMBLY (BASKET END, LID)
1		1	D2327-1	SPACER BUSHING
2	1		D2327-3	SPACER BUSHING
3	1		D3759-1	BUSHING
4	1		D3825-1	RIB
5		1	D3825-3	RIB
6	4	2	D4021-9	BUSHING

NOTES:

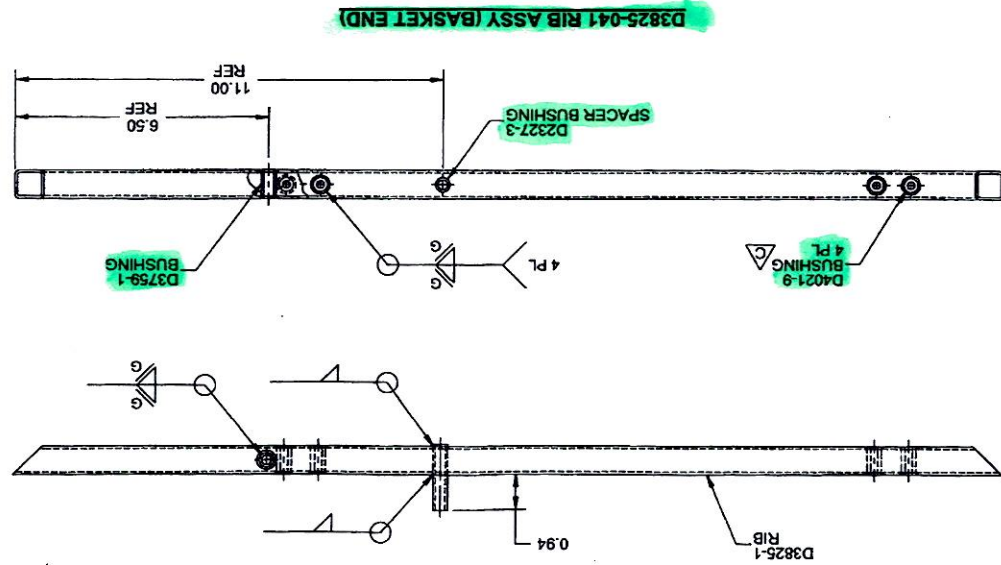
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3825-041 = 1.27 lbs; D3825-043 = 1.23 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
2012-08-03
WP

C	QTY(4) D4021-9 ON -041 AND QTY(2) D4021-9 ON -043 WERE D3759-1. CORRECTED DIM (2N B3-4) WAS 14.875. REASON FOR CHG. AND SIZE BOLTS REQ'D IN THOSE LOCATIONS.	MB	12.07.18
B	QTY(5) FOR D3759-1 WAS QTY(1); AFFECTS D3825-041/-1 (ZNS D3-1, C4-2, C3-2, D4-4, C6-4, C4-4, C3-4). ADDED D3825-043/-3. REASON: PAR10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>LB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>LB</i>	DRAWING NO. D3825	REV. C SHEET 1 OF 4
CHECKED	<i>AP</i>	TITLE RIB ASSY (BASKET END)	SCALE NTS
MFG. APPR.	<i>AP</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED	<i>AP</i>	DATE 12.07.18	

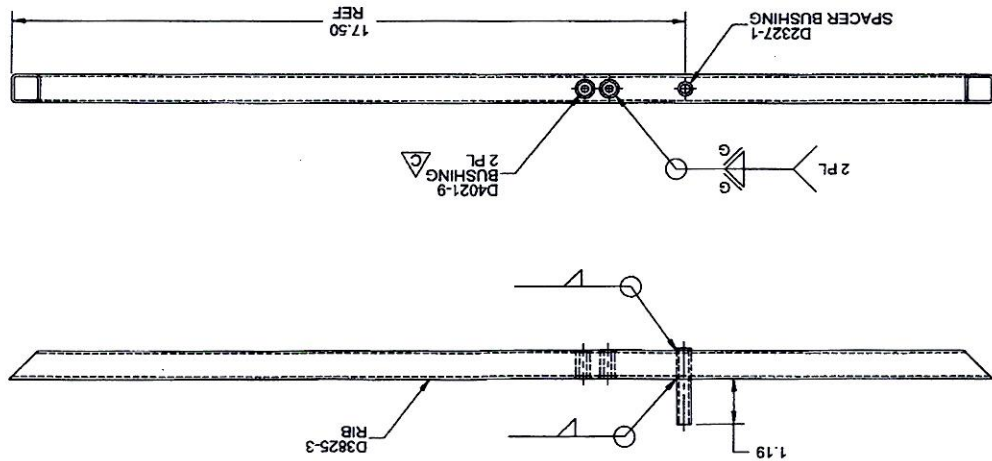
DESIGN	DATE	12.07.18
DRAWN	DE APPR.	
CHECKED	APPROVED	
DRAWING NO.	MFG. APPR.	
D3825		
REV. C		
SHEET 2 OF 4		
SCALE		
NTS		
DART AEROSPACE LTD		
HAWKESBURY, ONTARIO, CANADA		
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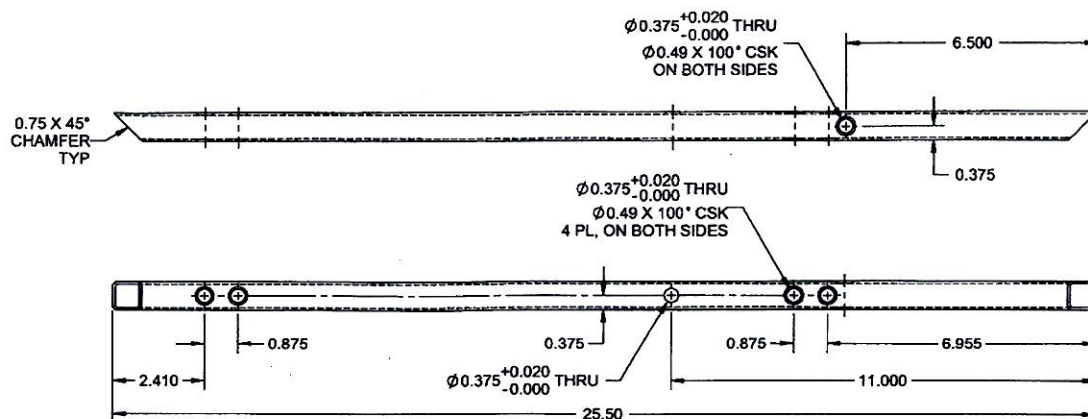
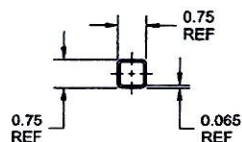


DESIGN	DATE	12.07.18
DRAWN	DE APPR.	
CHECKED	APPROVED	
DRAWING NO.	MFG. APPR.	
D3825		
REV. C		
SHEET 3 OF 4		
SCALE		
NTS		
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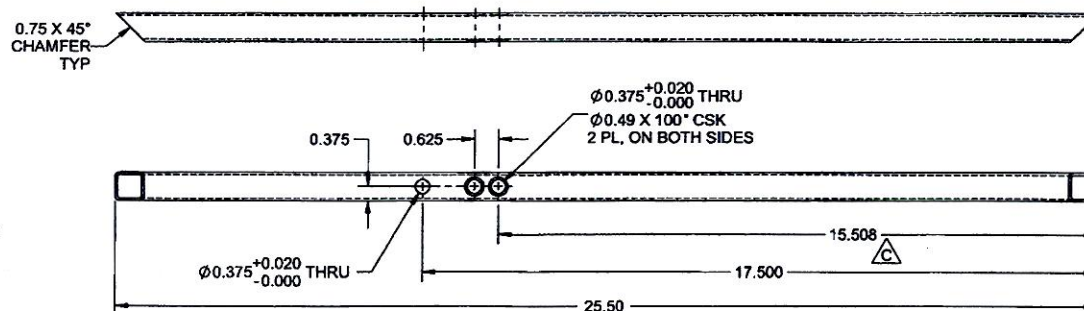
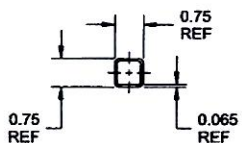
D3825-043 RIB ASSY (BASKET END, LID)



RELEASED
2012-08-03



D3825-1 RIB



D3825-3 RIB

RELEASED
2012-08-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3825	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	12.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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